

Work Order ID 101349

Mon-08-13 8:49:53 AM

101349

Item ID: D4463-11

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Tank Front

Start Date: 5/08/13 Start Qty: 5.00

*5/6
*5/6

Cust Item ID:

Required Date: 5/15/13 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 13 05-08 Tooling:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4463

C

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg

Prog rev: C

Dwg rev: C

6 0 JMB-5-8

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

6 0 JMB-5-8

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
BS8

6

Work Order ID 101349

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Item ID: D4463-11

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tank Front

Start Date: 5/08/13 Start Qty: 5.00

5

Cust Item ID:

Required Date: 5/15/13 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

16 0 DAS 19 9-82 13-05-14

170

Identify as per dwg & Stock Location: WNA-003 0.00

170

Packaging

Memo

0.00

Packaging

6 0 13-05-14

180

QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

0.00

Quality Control

13/5/15 MF 13-5-15

Picklist Print

May-08-13 8:49:57 AM

Page 1

Work Order ID: 101349

101349

Parent Item: D4463-11

D4463-11

Parent Item Name: Tank Front

Start Date: 5/08/13

Required Date: 5/15/13

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

100

sf

411.2125

11.5

~~60.52632~~

**

60

JM135-8

M6061T6S 063

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

411.2125

123135

120.5625

124003

80.9

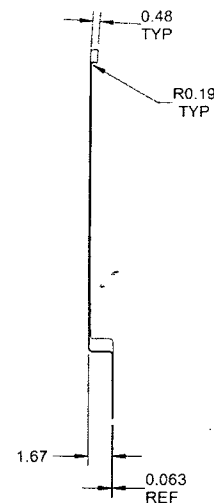
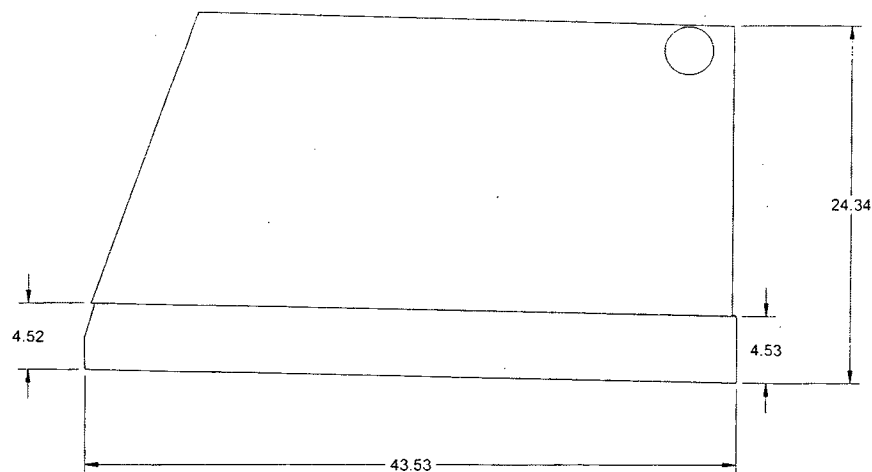
125431

209.75

125431

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue	KJ	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	



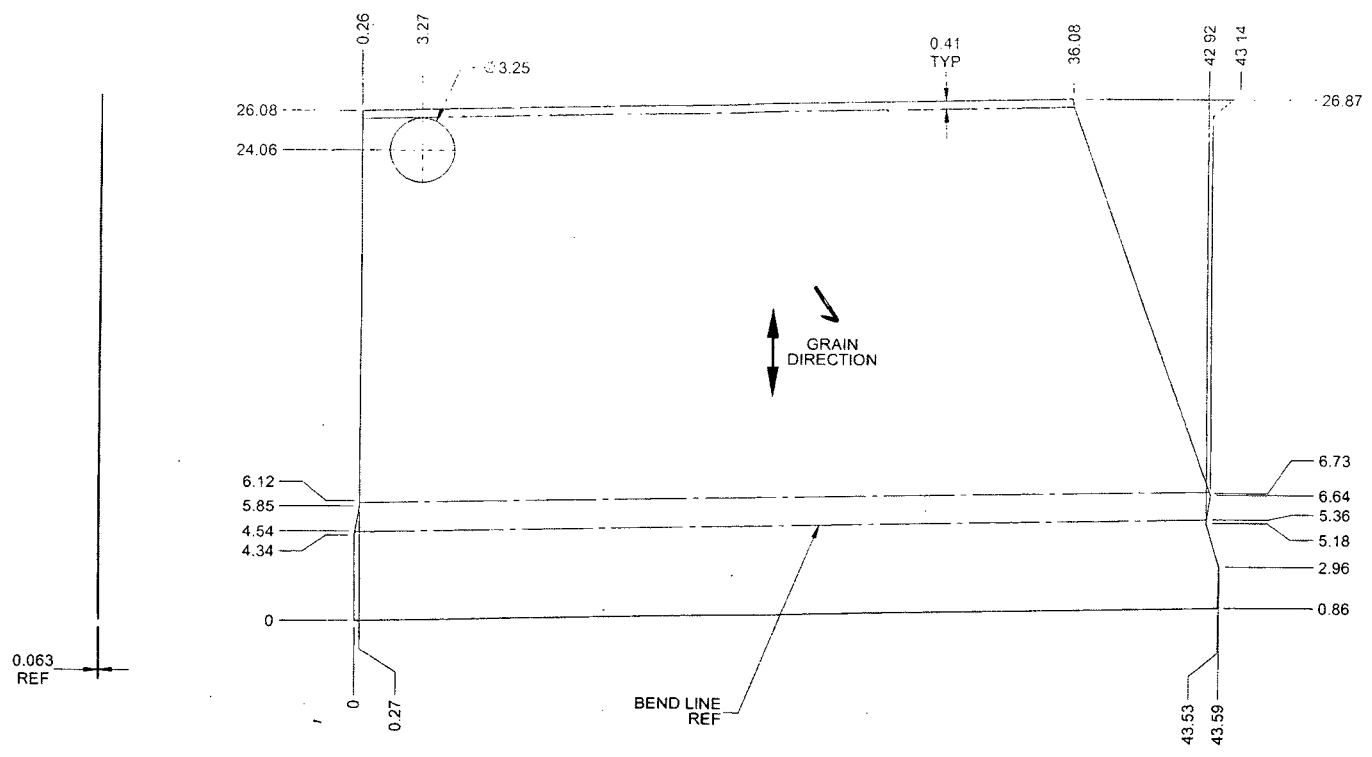
SHOP COPY
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 UNCONTROLLED COPY
 SUBJECT TO CHANGE
 WITHOUT NOTICE
 WORK ORDER
 NO. 101349 M15
 1305-08

RELEASED
 2012-04-24

D4463-11 TANK FRONT

- NOTES:
- 1) MATERIAL: MADE FROM D4463-11F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.40 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4463	SHEET 11 OF 14
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	TANK	NTS
DATE	12.03.23	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.40 lbs

D4463-11F FLAT PATTERN

DESIGN		DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	FE	D4463	SHEET 12 OF 14
APPROVED	140	TITLE	SCALE
DE APPR.	140	TANK	NTS
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